

# Work Order ID 62879

Tuesday, October 12, 2010 1:05:05 PM



Page 1

Item ID: D117-762-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3582

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

*N/A*

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3, use bending aid DT9632  
2- cut fwd end of tube as per dwg

*[Signature]*

*10-10-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Skidtubes

Skidtubes

Skidtubes

Memo

1-Cut Aft end using DT8185

2-Deburr ends

3-Drill Aft Cap holes using DT8678 \*\*\*DO NOT OPEN AFT CAP HOLE\*\*\*

4-Locate DT 8973 &amp; Drill Ground wire hole on top of Tube.

5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

6-Drill pilot holes for wearplates using DT8974

7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

8- open ground wear holes to 0.391" as per section B-B

9-Open Aft Cap holes using .209" drill.

10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

1 - BE 10/10/18

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  Skidtubes	Skidtubes	0.00				1	-	BE 10/10/19	
Skidtubes	<b>Memo</b> 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD Batch: <u>m115778/m111385</u> 2-Grind flush	0.00							
150  QC	QC10- Inspect visual per QSI004- ground welds	0.00				1			10-10-19
Quality Control	<b>Memo</b>	0.00							
160  QC	QC5- Inspect part completeness to step on W/O	0.00				1			10-10-19
Quality Control	<b>Memo</b>	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

180

QC3- Inspect Part Finish

0.00

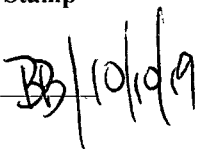
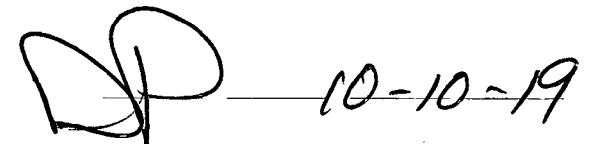


QC

Memo

0.00

Quality Control



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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 & OSI 015

A/R 241 Sike Flex

Batch:

Exp Date: 11/10/12

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD

Batch:

6-Grind welds flush

200

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

DP 10-10-19

BB 10/10/20

BE 10/10/21

BE 10/10/21

1 10/10/22

W/O:		WORK ORDER CHANGES					
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Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				1			<i>10-10-22</i>
215  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo	0.00  0.00				1	0		<i>PTO =&gt;</i>
220  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115291</i> Memo START TIME <i>9:15</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:45</i>	0.00  0.00				0			

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/22	215	Re iodine Touch-up AS per PAR 09-043 permanant change!	JEH	10/10/22	(X1)		8 16/10/22

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

QC3- Inspect Part Finish

0.00

=) YL

10/10/26

1

Ø



QC

Memo

0.00

Quality Control

240

HandFinishing

0.00



HandFinish

Memo

0.00

=) YL

10/10/26

1

Ø

Hand Finishing

✓ Install Wearplate &amp; Ground Wire inserts as per Dwg D3582.

W/O:		WORK ORDER CHANGES					
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	HandFinishing	0.00							
	HandFinish								
Hand Finishing	<p>Memo</p> <p>1-Inspect for Foreign objects</p> <p>2-Install Aft cap as per Dwg D3582, Detail "C"</p> <p>A/R 241 Sika Flex Batch: <u>1115115</u></p> <p>Exp Date: <u>11/01</u></p> <p>3-Install Wearplates as per Dwg D3582,</p> <p>Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582</p> <p>*****Do not install bolts where indicated on Dwg(Note #6)*****</p> <p>A/R 241 Sika Flex Batch: <u>1115114</u></p> <p>Exp Date: <u>11/01</u></p> <p>4-assemble o'ring as per dwg D3492 and apply o'ring lube</p> <p>A/R 55-o'ring lube batch: <u>1114189</u></p> <p>5- Wing Walk as per Dwg <u>D3043</u> and QSI 005 4.4</p> <p><u>10/10/07</u></p>	0.00							
260	QC5- Inspct part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D117-762-041								
	Location: _____								
	PPP Rev: _____								
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/11/10  
10-10-29  
C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 62879

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A ☐ 07.06.11 ☐ New Issue ☐ EC  
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2962-150		Manufactured	No				Each	100.0000	1	1			
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3.540 Outer Tube, Extrut

Location	Loc Qty	Loc Code
HALL	100	
28672	27	
59934	73	

② DP 10-10-18

D2964		Manufactured	No			140	Each	19.0000	1	1			
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Cap

Location	Loc Qty	Loc Code
LG	19	
14101	19	

BE 10-10-19

D2971		Manufactured	No			190	Each	27.0000	1	1			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	27	
44445	27	

BE 10/10/20  
BB 10/10/20

D3584-1		Manufactured	No			190	Each	0.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Web

B 62884

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2973

Manufactured No

190 Each

162.0000

2 2



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

162

14636

162

D3662-3

Manufactured No

190 Each

27.0000

1 1



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

27

44456

27

D3662-1

Manufactured No

190 Each

19.0000

3 3



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

19

55328

19

ALS4-1032-130

Purchased No

240 Each

1,047.000

36 36



Insert

Location

Loc Qty

Loc Code

PKG11

998

114723

998

ST282

10

110511

10

ST381

39

114654

39

1115911

X36

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Shop Packet Print

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Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-428-165

Purchased

No

240

Each

107.0000

2



Inserts



HL 10/10/26

Location

Loc Qty

Loc Code

FP

7

6989

7

Y2

ST282

100

114172

100

D2965

Manufactured

No

250

Each

42.0000

1



Cap, 105 Skidtube



HL 10/10/26

Location

Loc Qty

Loc Code

FP4

42

52057

42

Y1

D3508-3

Manufactured

No

250

Each

2.0000

1



Wearplate



HL 10/10/26

Location

Loc Qty

Loc Code

FP

1

38527

1

FP21

1

55339

1

Y1

D3508-9

Manufactured

No

250

Each

4.0000

1



Wearplate



HL 10/10/26

Location

Loc Qty

Loc Code

FP21

4

54580

4

Y1

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 62879

Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010



Start Qty: 1.00

Required Qty: 1.00

D3558-3	Manufactured	No	250	Each	13.0000	1	1
							<u>10/10/26</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	13	
42253	1	
<u>55468</u>	12	<u>X1</u>

D3558-9	Manufactured	No	250	Each	18.0000	1	1
							<u>10/10/26</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	18	
50928	4	<u>X1</u>
55469	14	

D3558-11	Manufactured	No	250	Each	3.0000	1	1
							<u>10/10/26</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	3	
42254	3	<u>X1</u>

D3558-13	Manufactured	No	250	Each	35.0000	1	1
							<u>10/10/26</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	35	
55467	1	<u>X1</u>
59558	34	

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 62879

Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010



Start Qty: 1.00

Required Qty: 1.00

D3508-11	Manufactured	No	250	Each	12.0000	1	1
							<u>HL 10/10/26</u>
Wearplate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP16	12	
<u>54644</u>	12	

D3508-13	Manufactured	No	250	Each	3.0000	1	1
							<u>HL 10/10/26</u>
Wearplate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	3	
<u>54645</u>	3	

D3492-051	Manufactured	No	250	Each	54.0000	2	2
							<u>HL 10/10/26</u>
Plug Assembly							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP013	54	
<u>44633</u>	4	
<u>55622</u>	50	

D3492-049	Manufactured	No	250	Each	29.0000	2	2
							<u>HL 10/10/26</u>
Plug Assembly							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP011	29	
<u>55621</u>	29	

D3492-053	Manufactured	No	250	Each	19.0000	6	6
							<u>HL 10/10/26</u>
Plug Assembly							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	19	
<u>54641</u>	19	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, October 12, 2010 1:05:09 PM

Work Order ID: 62879



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased No

250 Each

0.0000

2 2



11114328



x2 JH 10/10/26

Washer

AN3C4A Purchased No

250 Each

1,511.000

28

28



JH 10/10/26

BOLT

## Location

## Loc Qty

## Loc Code

ST245

20

110139

20

ST303

3

115438

3

ST350

1488

114108

14

114416

12

114523

2

115300

460

115589

1000

x28

AN3C5A Purchased No

250 Each

1,169.000

2

2



JH 10/10/26

Bolt

## Location

## Loc Qty

## Loc Code

ST350

1159

114330

11

115015

16

115371

100

115422

100

115594

432

115835

500

x2

ST351

10

113121

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 62879

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L NAS1149D0416J Purchased

No

250

Each

223.0000

2

2



Washer



HL 10/10/26

Location

Loc Qty

Loc Code

ST346

223

106785

2

110153

221

x2

AN960C10L NAS1149C0332 Purchased

R

No

250

Each

29.0000

28

28



washer



M115832

x28 HL 10/10/26

Location

Loc Qty

Loc Code

ST245

29

107534

29

AN4-4A Purchased

No

250

Each

186.0000

2

2



Bolt



HL 10/10/26

Location

Loc Qty

Loc Code

ST356

183

114615

183

ST361

3

108138

2

111295

1

y2

NAS1611-012 Purchased

No

250

Each

110.0000

6

6



O-RING



HL 10/10/26

Location

Loc Qty

Loc Code

FP

110

108673

9

113845

101

x6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Tuesday, October 12, 2010 1:05:09 PM

Work Order ID: 62879



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-015

Purchased

No

250

Each

25.0000

2

2



O-RING



10/10/26

Location

Loc Qty

Loc Code

FP

25

107178

5

115101

20

10/10/26

NAS1611-016

Purchased

No

250

Each

109.0000

2

2



O-RING



10/10/26

Location

Loc Qty

Loc Code

FP

109

107178

9

112492

50

113524

50

10/10/26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

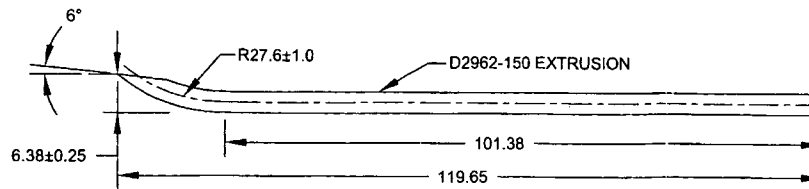
**NOTE:** Date & initial all entries

# PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

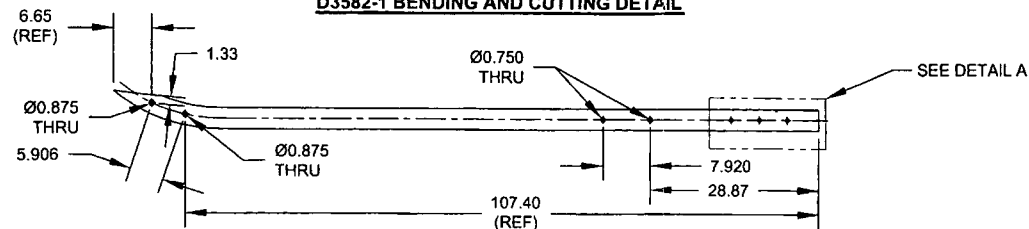
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

## GENERAL NOTES:

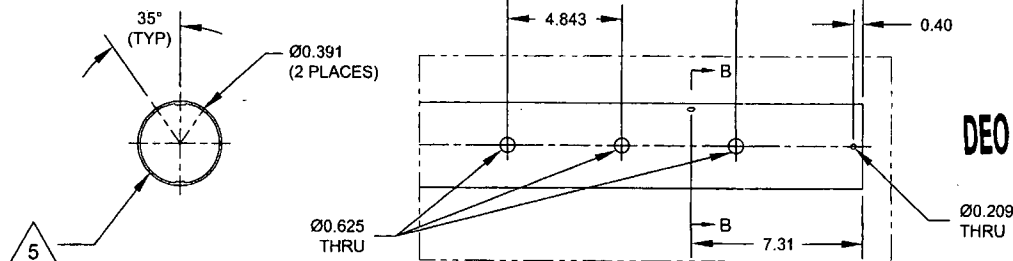
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
  - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
  - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
  - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B  
SCALE 1:5

DETAIL A  
SCALE 1:5

RELEASED  
07.11.2012

A NEW ISSUE		PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3582	SHEET 1 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

NO. 42879-  
P1 10-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

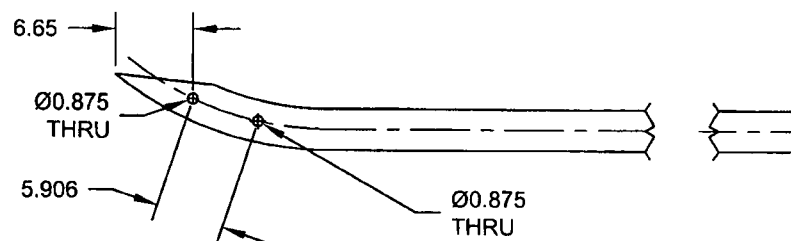
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

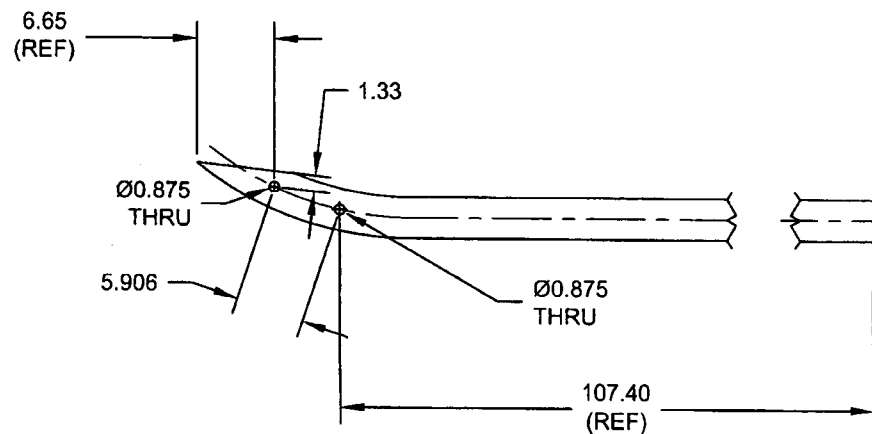
DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>PH</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 09/04/06		DATE 09.04.06		

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:  
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



**RELEASED**  
09/04/22 *[Signature]*

*W/O 02877*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries